

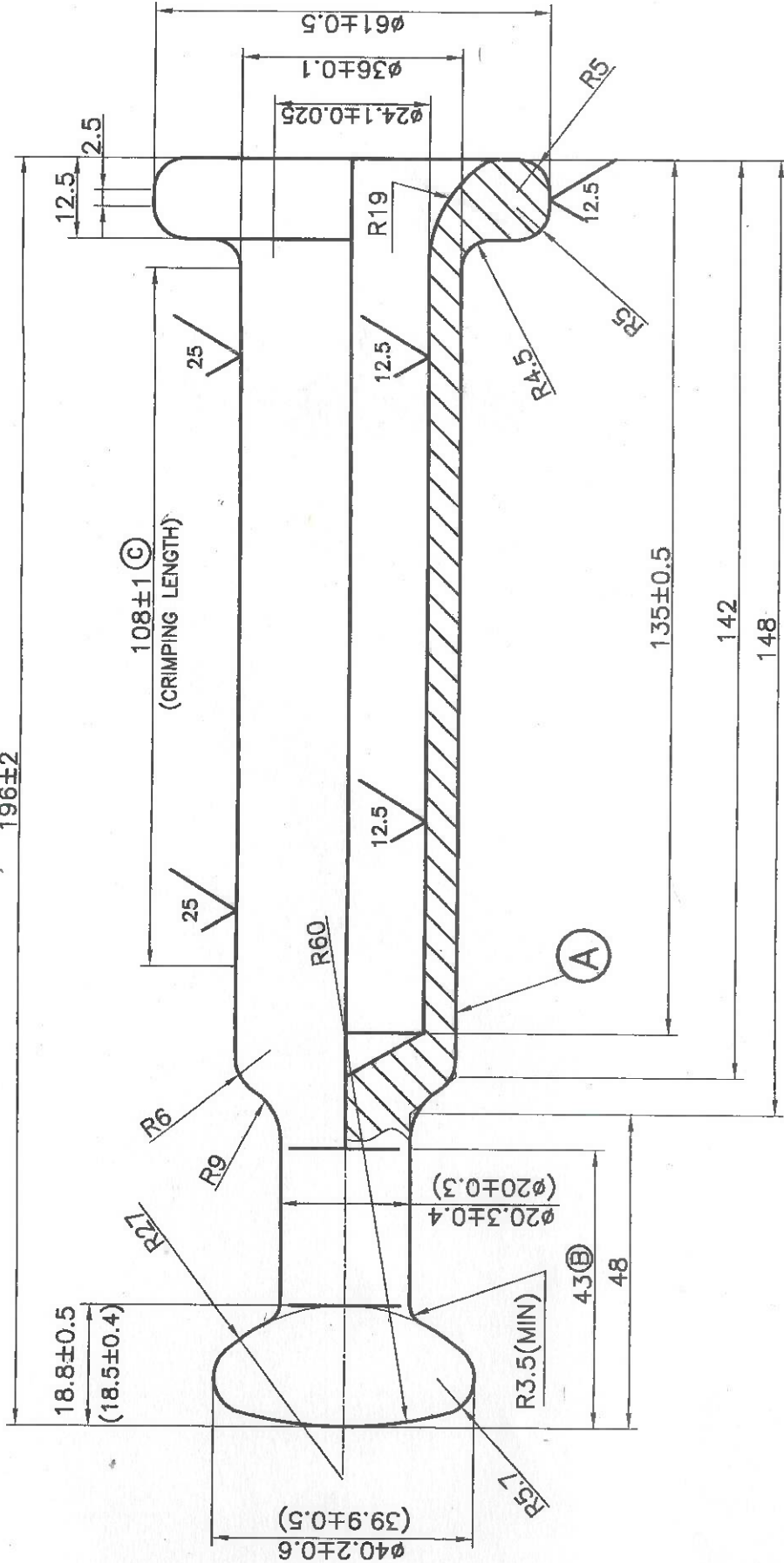
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REV
Z2291 60 786 3
ON DRG

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REF. DRG. No.

SIGN AND DATE

INVENTORY No.



NOTES:

- 1 ALL DIMENSIONS ARE AFTER HOT-DIP GALVANISING.
A THICKNESS OF 0.15 mm MAY BE ASSUMED FOR GALVANISING.
- 2 DIMENSIONS INDICATED IN BRACKETS REFER TO BEFORE GALVANISING STAGE
- 3 BALL FITTINGS ARE TO BE MADE BY FORGING PROCESS ONLY
- 4 MATERIAL TO CONFORM TO GRADE 080M40 OF BS EN:10083-1:1991 (EN-8)
- 5 IF THE FORGED SURFACE IS NOT SMOOTH AT THE PORTION (B) & (C) BALL FITTINGS ARE TO BE MACHINED AT THAT PLACE WITH THE HELP OF A 'FORM TOOL' TO GET A SMOOTH SURFACE.
- 6 AFTER GALVANIZING THE BALL PORTION SHOULD ANSWER TO ALL THE RELEVANT "GO AND NO GO" GAUGES RECOMMENDED BY IEC Pub.60120 OR LATEST (20 mm DESIGNATION) UP TO PORTION (B)
- 7 SUPPLIER'S IDENTIFICATION MARK & RATING SHALL BE PROVIDED IN DEPRESSED FORM IN 6 mm LETTER SIZE AT PLACE SHOWN AS (A)
- 8 SEQUENCE OF OPERATIONS :
A) BALL FITTINGS ARE NORMALISED AFTER FORGING
B) MACHINING (IF NECESSARY - SEE NOTE No.5)
C) HARDENING & TEMPERING AND SHOT BLASTING.
D) GALVANISING.
E) BORING.
- 9 BEFORE GALVANISING THE BALL PORTION SHOULD ANSWER TO "GO AND NO GO" GAUGES TO DRG. No. 4 SK 0260 LATEST REVISION, 4 SK 0261 LATEST REVISION AND CLAUSES B7.88 & B9 OF IEC Pub.60120 (20 mm DESIGNATION) UPTO PORTION (B)
- 10 BALL FITTING SHALL WITHSTAND A MINIMUM TENSILE STRENGTH OF 200 kN
- 11 MPI TEST TO BE CARRIED OUT ON ALL FORGED FITTINGS
- 12 BORE HAS TO BE DONE ONLY AFTER GALVANISING
- 13 DIM $\phi 24.1 \pm 0.025$ TO BE CHECKED BY "GO & NO GO" GAUGES.
- 14 THE WEIGHT OF FORGED BALL FITTING AT BLACK STAGE IS 1.4 kg.(APPROX)
- 15 DIM 135 ± 0.5 TO BE CHECKED BY "GO & NO GO" GAUGES OF DRG. No. 4 SK 2723

CONTROLLED COPY

FERROUS PARTS ARE HOT-DIP GALVANIZED (EXCEPT FEMALE THREADS) AS PER IS:2629 AND TESTS CONFORM TO IS:2633

BHARAT HEAVY ELECTRICALS LTD,
ELECTROPORCELAINS DIVISION
BANGALORE 560 012

NAME N.CHIKKANNA
SIGN
DATE 04/02/11

REV 03
DATE 04/02/11
ALTERED
CHECKED

ALTERED
CHECKED

DATE

REV

ALTERED
CHECKED

DATE

REV

1. DRAWING REDRAWN & REVISED
 2. DIM 135 ± 0.5 WAS 135
 3. NOTE NO. 15 ADDED
- REFER TO PH No.5429

DEPT
CODE

GRADE OF
TOL DIM
C/M/F

SCALE
N T S

WEIGHT (kg)
0.9
(Approx)

REF TO ASSY.DRG
3 987 09 15332

ITEM No. OF
No.

4/2/11

TITLE
BALL FITTING FOR 160kN COMPOSITE
LONG ROD INSULATOR

CARD
CODE

DRAWING No.
3 987 09 15322

REV.
03